



Nexus HF 600

Hardfacing electrode

Rutile - Basic coated electrode for surfacing of components subject to intermediate shock and abrasion. The deposit is suitable for resurfacing crusher jaws, bucket teeth, moulds, cutting tools and conveyer screws.

Nexus 309L electrode may be used as a buffer layer prior to surfacing with Nexus HF600.

International Standards

BSEN DIN8555
E2-UM-60

Typical All-Weld Metal Analysis (wt%)

C	Si	Mn	Cr
1.0	0.50	1.30	1.30

Typical All-Weld Metal Mechanical Properties

Brinell Hardness	Rockwell C Hardness
580-610	55-60

Welding Positions

All positions.

Applications

Bulldozer blades, pulping knives, pump parts, mixer paddles, crusher jaws, mineral deflector plates, moulds, chisels and cutting tools.

Packaging

Size mm	3.2 x 450	4.0 x 450	5.0 x 450
Pieces/Package	141	93	64
Kg/Package	5	5	5

Operating Requirements

DC- AC(45ocv min)	115 A	160 A	230 A
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Additional Information

Material safety data sheet	MSDS 5
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Notes

Best results are achieved by using the low amps to avoid dilution with any softer base material, welding with 50% of the bead overlapping the adjoining bead also reduces dilution. Depending on the base material it may be necessary to preheat to 200-400°C
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